

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019788**Date Inspected:** 15-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Kelly Leavitt, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 10

This QA Inspector observed the following work in progress for Bay 10.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Yu Zhi Lai.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Bike Path

PCMK: BK004A2-029

Weld No: 001,004,005,006,008,010,013,038,

Welder: 032075

WPS-B-T-2132-ESAB

Bay 16

This QA Inspector observed the following work in progress for Bay 16.

ZPMC was using the Shielded Metal Arc Welding (SMAW) process.

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ZPMC QC is identified as Guo Xing Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Steel Barrier

PCMK: E5-SB029-003

Weld No: fit up

Tack Welder: 201080

WPS-B-T-2113-Fmc-1

Component; Steel Barrier

PCMK: E5-SB002-015

Weld No: fit up

Tack Welders: 201891, 201912

WPS-B-T-2113-Fmc-1

Component; Steel Barrier

PCMK: E5-SB002-014

Weld No: fit up

Tack Welder: 201905

WPS-B-T-2113-Fmc-1

Bay 19

This QA Inspector observed the following work in progress for Bay 19.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Guo Xing Hui.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Suspender Brackets

PCMK: SB024-108

Weld No: 021,101

Welder: 062762

WPS-B-T-2233-ESAB

Component; Suspender Brackets

PCMK: SB025-108

Weld No: 016,022,049,051

Welders: 062762, 062783

WPS-B-T-2233-ESAB

Bay 28

This QA Inspector observed the following work in progress for Bay 28.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

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ZPMC QC is identified as Yang Bai Qiang.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA Inspector.

Component; Steel Barrier

PCMK: E5-SB13016

Weld No: 032~043

Welder: 062265

WPS-B-T-2233-ESAB

Blast Bay 1

This Caltrans QA Inspector performed a pre-blast visual inspection of the interior surface and internal components, East Tower Lift 4 subassembly, 116~131 meter mark to the bottom surface of the double diaphragm. Surface defects and base metal surface irregularities that required grinding were marked up with colored chalk, and weld defects that require welding were taped with gray masking tape for repair after the coating has been applied. ZPMC QC and ABF inspection personnel were present during the inspection and informed of QA findings.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No significant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt,Kelly	Quality Assurance Inspector
Reviewed By:	Riley,Ken	QA Reviewer
